

Work Order ID 82184***82184***

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Friday, March 23, 2012 1:43:21 PM

Item ID: D4407-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 3/26/2012 Start Qty: 6.00

6

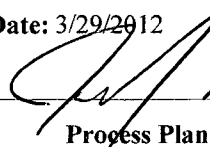
Cust Item ID:

Required Date: 3/29/2012 Req'd Qty: 6.00

6

Customer:

Reference:

 12.03.23

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4407	B								

100

0.00

100

29 12.3.20

6

φ

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 66.10"

110

0.00

110

20 12.3.20

6

φ

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio EB082 & dwg D4407,

FOLIO REV: 14DWG REV: 15

2-Deburr as required

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Friday, March 23, 2012 1:43:21 PM

Item ID: D4407-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 3/26/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/29/2012 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	29	12	3-28	6	4		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6	4		12/03/12
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo	0.00 0.00				(6)	MAL	12/04/04	

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/26/2012 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 3/29/2012 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/4/59

MF

12-04-04

Picklist Print

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Work Order ID: 82184

Parent Item: D4407-1

Parent Item Name: Bar

Start Date: 3/26/2012

Required Date: 3/29/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD
JFS verified by:JLM

IPP revB 12/02/13 Now on cnc

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	295.5490	5.508	34.787368			

Location

Loc Qty

Loc Code

MAT006

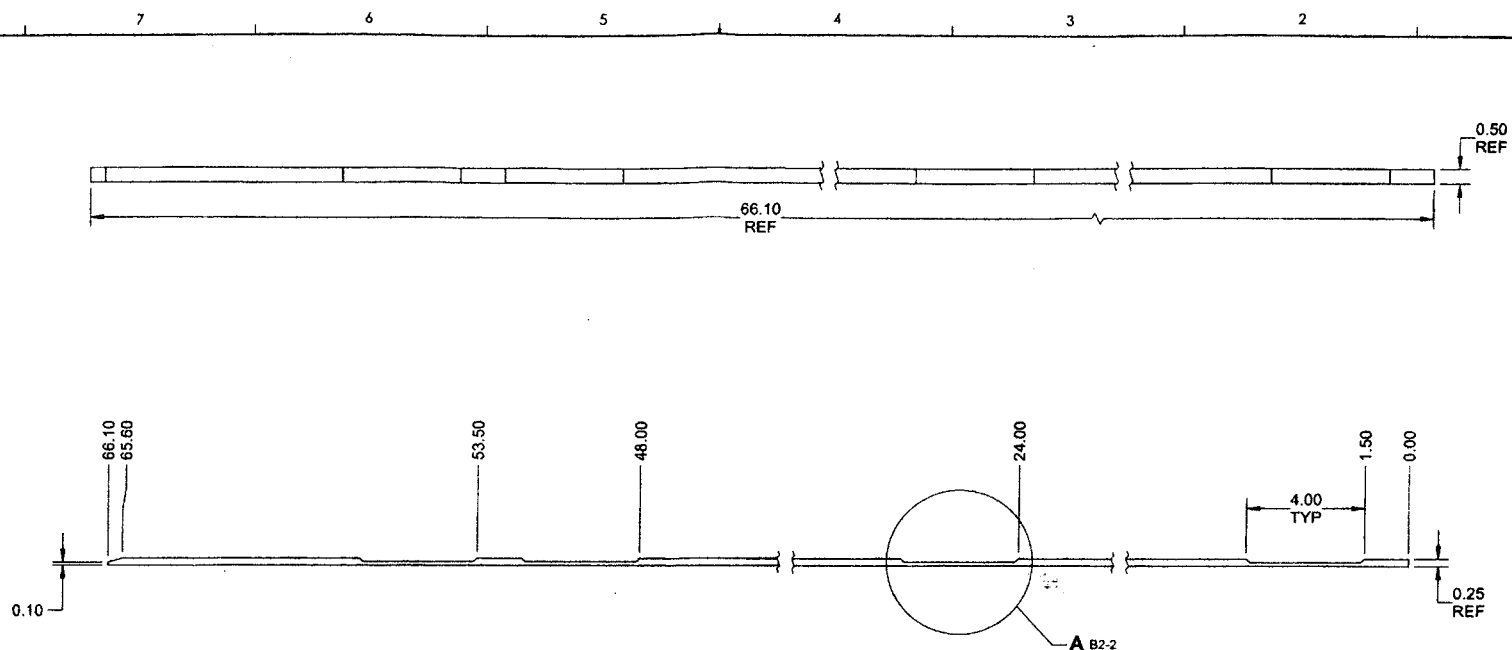
295.549

120696✓

295.549

20 12-3-2f

33.05



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.11 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4407	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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